

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005651**Date Inspected:** 05-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG				

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

OBG Bay 14: QA Inspector performed ultrasonic verification testing of OBG deck plate segments 008-001 thru 008-004 and 008-069 thru 008-071 Complete Joint Penetration (CJP) butt joints. The Ultrasonic Testing (UT) was performed to verify that 10% of the weld meets the requirements of the contract documents and AWS D1.5-2002 after ZPMC QC UT acceptable inspection. The welds and base metal were scanned utilizing a Krautkramer Branson USN 58L #01WK8K. QA Inspector performed a base metal lamination check using a 25mm diameter 2.25 MHz transducer and a shear wave scan using a 20mm x 15mm 2.25 MHz transducer on a 70 degree angle wedge from face A. For details please see the ultrasonic testing report TL-6027 dated 04 Feb, 2009. QA Inspector found the welds for seg 008-002 thru 008-004 and seg 008-069 thru 008-071 inspected to be in compliance with AWS D1.5 2002 Table 6.3 and the contract documents. Weld for seg 008-001 was rejected by ZPMC QC UT Inspector and will be repaired and UT reinspected when complete.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

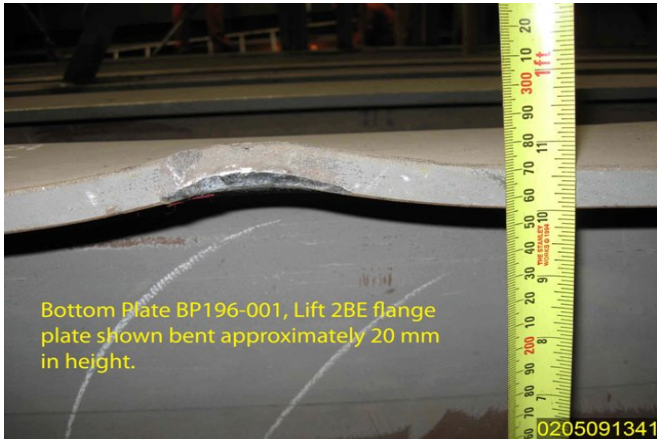
Summary of Conversations:

Bay 14 at 1300 Caltrans Quality Assurance (QA) Inspector observed the flange plate of one stiffener on Bottom Plate BP196-001 in lift 2BE to have been bent at some point of installation. Mishandled/bent area is approximately 230 mm length by 20 mm in height. QA Inspector notified ZPMC QC Inspector Zhang Xian Ji and QC CWI Chen

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Chih Ming of the bottom plates condition. ZPMC QC informed QA Inspector they are aware of the bottom plate's condition and have informed their office. Representative pictures shown below. Standard Specifications 1999 section 6-1.04 "Defective Materials" states "All materials which the Engineer has determined do not conform to the requirements of the plans and specifications will be rejected whether in place or not. The rejected materials shall be removed immediately from the site of the work, unless otherwise permitted by the Engineer. No rejected material, the defects of which have been subsequently corrected, shall be used in the work, unless approval in writing has been given by the Engineer. Standard Specifications 1999 section 55-1.04 "Shipping, Handling and Storing Materials" states "In handling and shipping of the steel work, every care shall be taken to avoid bending, scraping, or overstressing the pieces. All pieces bent or otherwise injured will be rejected".



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
